

Work Order ID 59839

Friday, June 11, 2010 2:39:00 PM



Page 1

Item ID: D4021-7

Revision ID:

Item Name: Hoop

Start Date: 6/11/2010 Start Qty: 6.00

Required Date: 6/18/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:



Date: 10-6-14 Tooling:

Cust Item ID:

QC:

Date:

SPC (Y/N):

Customer:

Setup Start



Stop



Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4021

Prog Rev:

Dwg Rev: B

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

MATERIAL NOT PULLED

10-6-15

(6)

10-6-15

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4021-7

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Item Name: Hoop

Start Date: 6/11/2010 Start Qty: 6.00

Required Date: 6/18/2010 Req'd Qty: 6.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check	0.00	S 1066121						

130



Small Fab

Small Fab

Memo

- 1- make radius as per dwg
- 2- deburr

0.00

0.00

→ m.f 10/06/21

(6x)

140

QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 1066121

(t6)

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Item ID: D4021-7

Accept



Setup Start



Revision ID:

Item Name: Hoop

Stop



Start Date: 6/11/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150



Packaging

Packaging

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampIdentify as per dwg & Stock Location: CWA

0.00

SAO 10-06-21

(6)

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/23 JJ

PBO-6-22
(4)

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Picklist Print

Friday, June 11, 2010 2:39:04 PM

Page 1

Work Order ID: 59839



Parent Item: D4021-7



Parent Item Name: Hoop

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:B as
DD 10.04.20 verified by:EC IPP Rev:C as per dwg revB

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ M304B0.625X3.000	Replacement 304 BAR .625 X 3.00	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 0.5735	Qty per Kit 0.4166	Total 2.631158	Qty	Date	Status
												WB10-6-15	

Location	Loc Qty	Loc Code
MAT53	0.5735	
112320	0.5735	112320

(6)

W/O:		WORK ORDER CHANGES					
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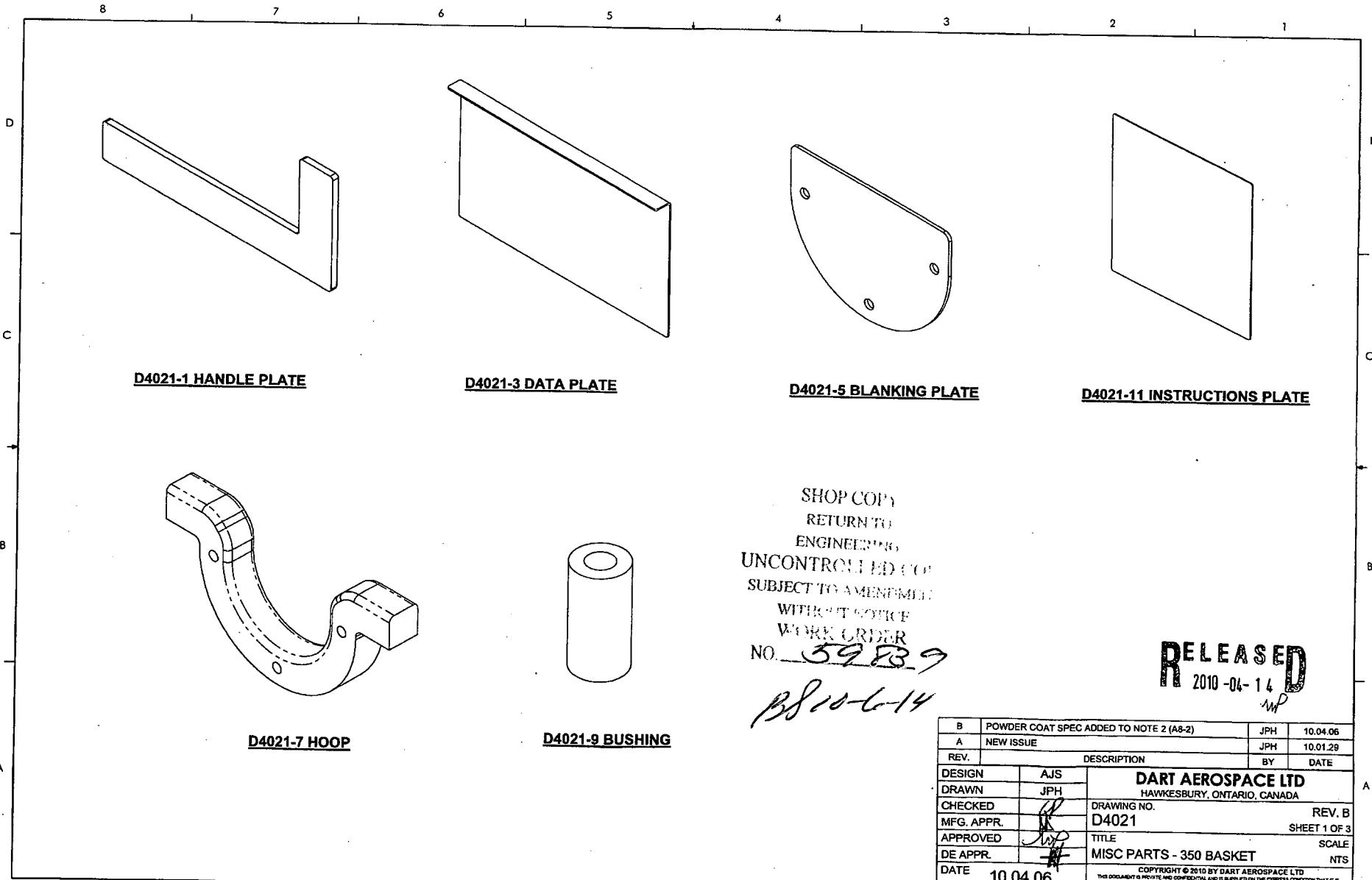
DART AEROSPACE LTD	Work Order:	<i>SG 839</i>
Description: Hoop	Part Number:	D4021-7
Inspection Dwg: D4021 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>8</u>	Prototype Approval:	N/A
Date:	<u>10-6-15</u>	Date:	<u>10/06/15</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	<i>[Signature]</i>

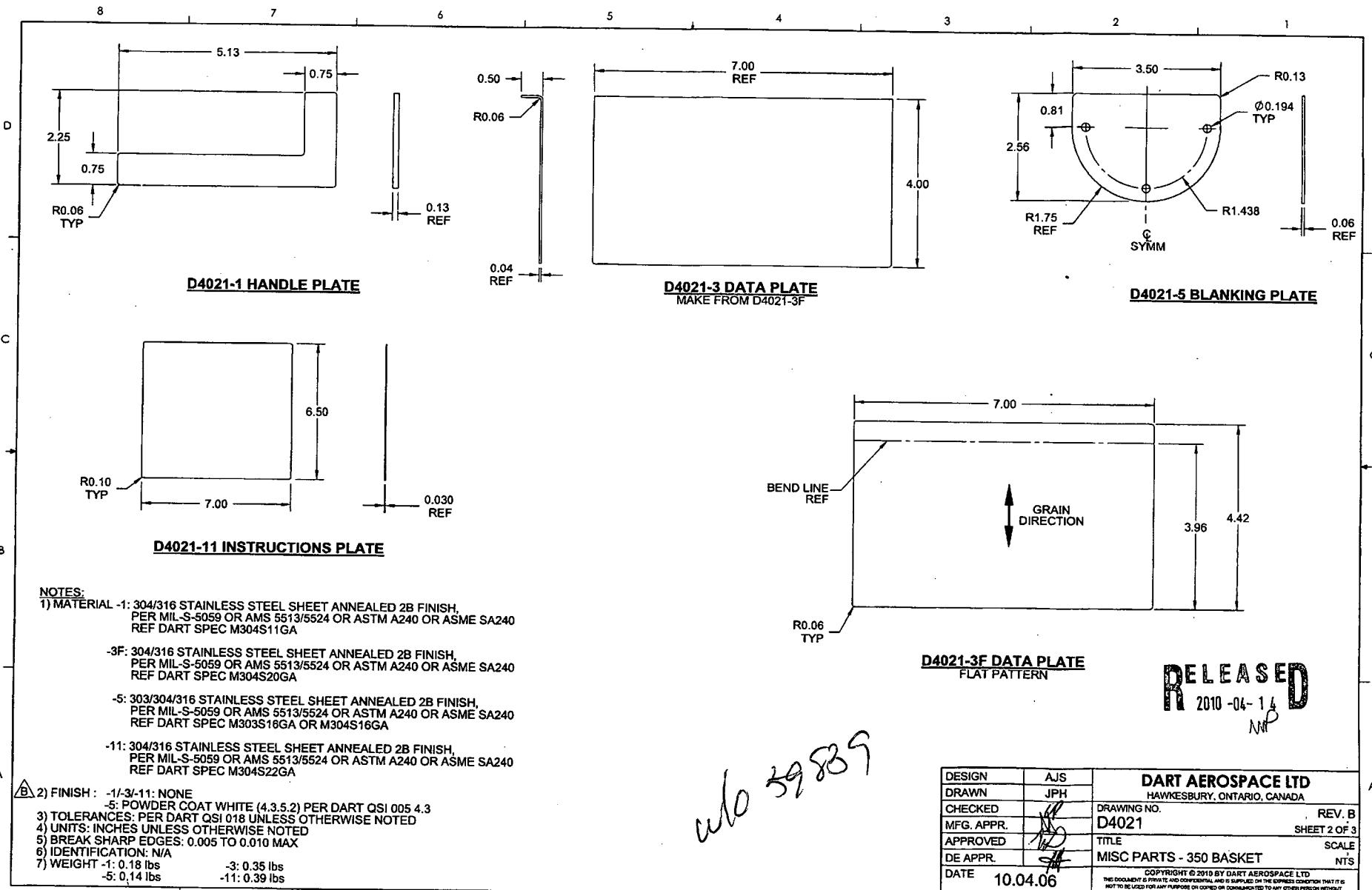


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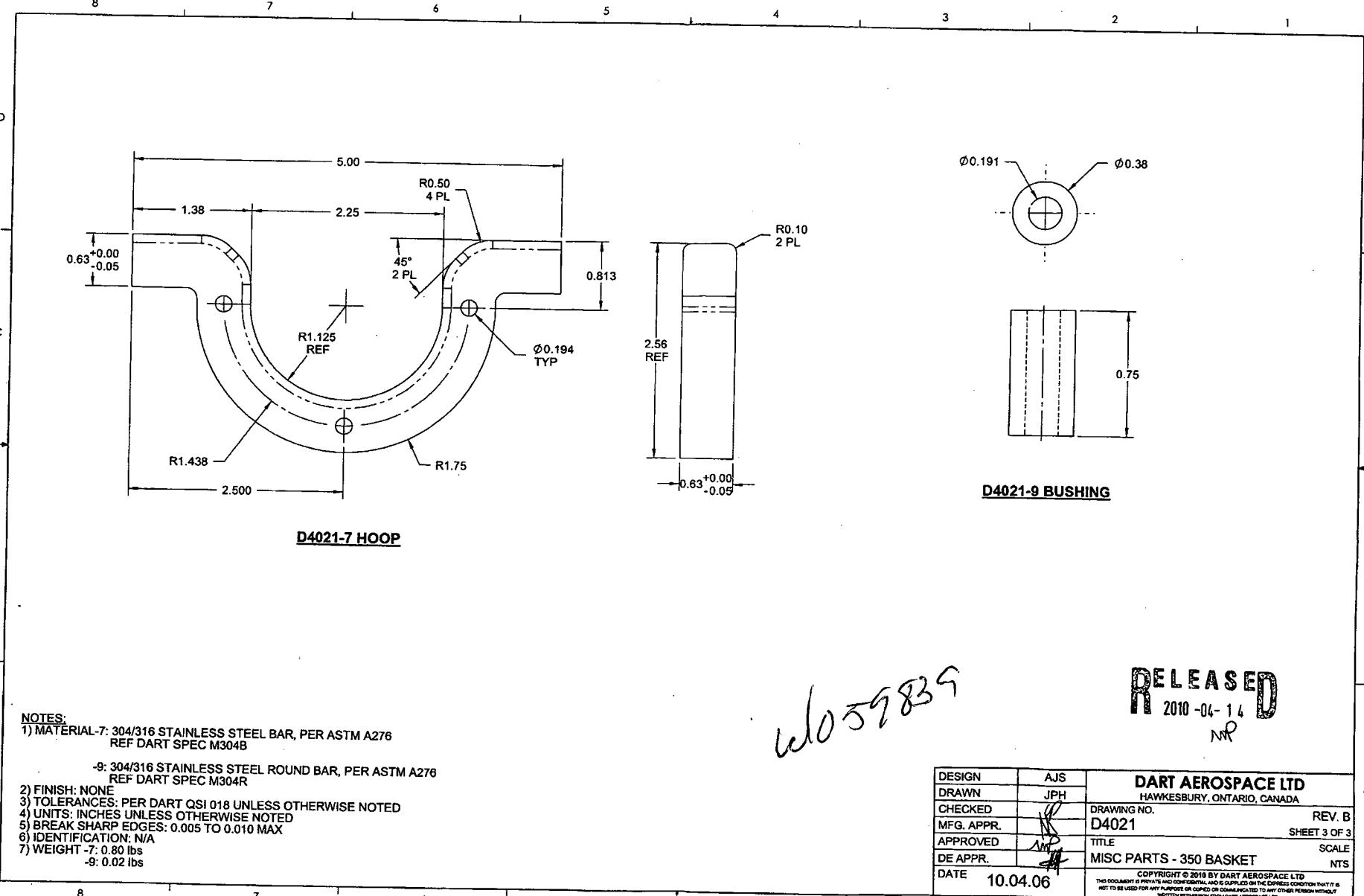


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W059839

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	AJS	DRAWING NO. D4021	REV. B SHEET 3 OF 3
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.06		SCALE NTS

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RELEASED
2010-04-14
NP

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